

Work Order ID 62727

Wednesday, October 06, 2010 3:59:19 PM



Page 1

Item ID: D3768-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Front Inboard Leg

Start Date: 10/6/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-10-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3768	Rev A								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-CUT TUBE TO LENGH AS PER DWG D3768 2-DRILL TUBE USING DT9044 AND AS PER DWG D3768 3-DEBURR								
110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

4x

⇒ m-l 10/10/13

8.10.10/14

x4

10-10-14

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62727

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Page 2

Item ID: D3768-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Front Inboard Leg

Start Date: 10/6/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

5:00

□ OVEN TEMPERATURE:

5:30 □ FINISH TIME:

320

④, ② 10-10-10

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> 10/10/10

J φ

150

Identify as per dwg & Stock Location: 250

0.00



Packaging

Memo

0.00

Packaging

Per 14/12/10

W/O:		WORK ORDER CHANGES					
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Work Order ID 62727

Wednesday, October 06, 2010 3:59:19 PM

Page 3

Item ID: D3768-1

Accept

Revision ID:

Item Name: Front Inboard Leg

Start Date: 10/6/2010 Start Qty: 4.00

Required Date: 10/15/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/18

mf

10-10-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 3:59:22 PM

Page 1

Work Order ID: 62727

Parent Item: D3768-1

Parent Item Name: Front Inboard Leg



Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-08-25 Rev B Added Drilling tooling JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6T1.000W065

Purchased

No

100

f

46.3595

0.8542

3.596632



6061T6 RD TUBE 1.00 x .065w



M-1 10/10/13

Location

MAT015

113511 ✓

114089

Loc Qty

46.35947348

36.4647365

9.894737

Loc Code

3.596632

W/O:		WORK ORDER CHANGES					
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SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62727

08-06-13-14

D3768-1 FRONT INBOARD LEG

D3768-3 FRONT OUTBOARD LEG, LH

D3768-4 FRONT OUTBOARD LEG, RH

RELEASED
08-06-13-14

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

A		NEW ISSUE		HS	08.06.04		
REV.		DESCRIPTION		BY	DATE		
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
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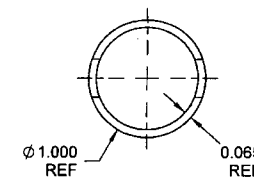
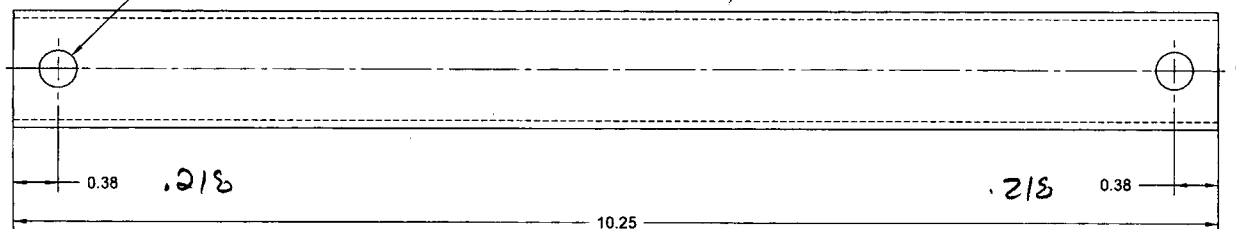
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Wb 42727

0161

Ø 0.323
THRU
2 PL



D3768-1 FRONT INBOARD LEG

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08.06.14

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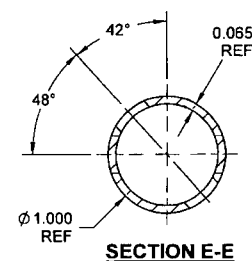
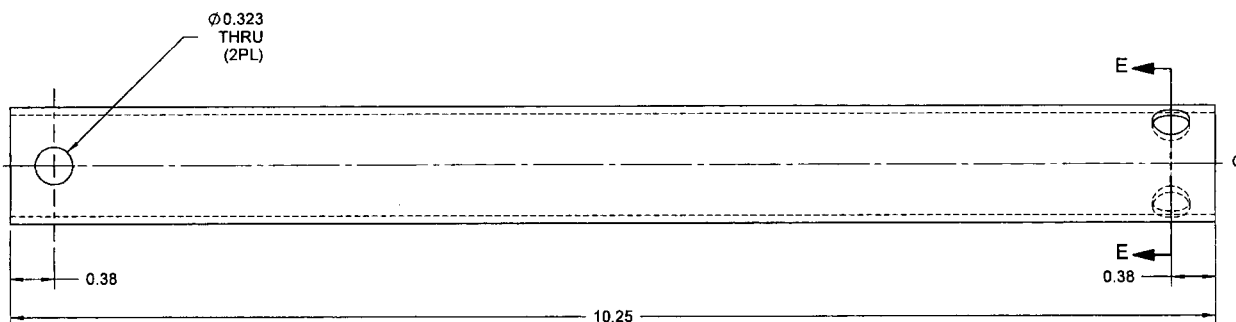
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W/O 62727



D3768-3 FRONT OUTBOARD LEG, LH

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08.06.04

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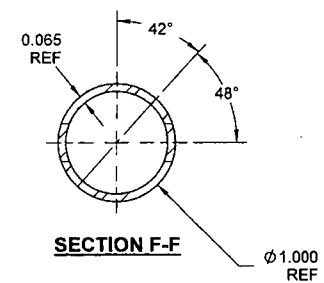
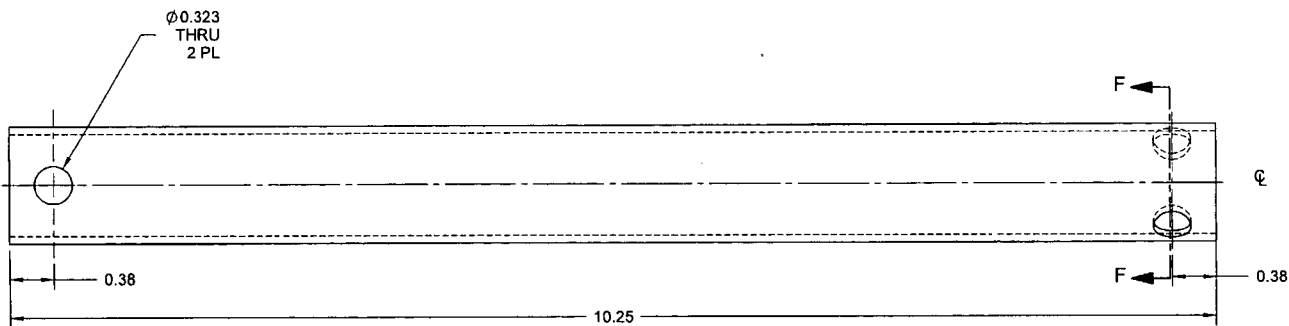
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

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W/O 62727



D3768-4 FRONT OUTBOARD LEG, RH

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08.06.04

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